

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029914**Date Inspected:** 08-Aug-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

CWI Name:	Jesse Cayabyab and Bernie Docena			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	SAS OBG and Tower		

Summary of Items Observed:

Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at the Self Anchored Suspension (SAS) job site as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

At the Tower Base Electro Slag Weld (ESW) 'V' weld joint #W-043 face B, ABF welder Mike Jimenez was observed continuing to perform excavation on welded ESW at location Y=5210mm to Y=5225mm due to UT detected rejects. The repair area was preheated to more than 350°F using propylene gas torch prior the excavation. ABF personnel used carbon air arc gouging followed by die grinder to excavate the defects. This excavation was performed per the Request for Weld Repair RWR#201305-009. ABF QC Jesse Cayabyab was noted on site monitoring the welder during the excavation. During the shift, excavation of the defect was still continuing and should remain tomorrow.

At the Tower Base Electro Slag Welding (ESW) Q joint E-043 location Y=5770mm face B, QA randomly observed ABF welder Donald Plum grinding the welded repair butt joint after welding from face B. The repair butt joint was initially tested by ABF QC Jesse Cayabyab using Ultrasonic Testing (UT) and found indications that prompted the welder to grind the opposite side where the repair was done. While grinding the other side of the repair joint was being undertaken, ABF QC Bernie Docena performed Magnetic Particle Testing (MT) and found linear indications. Due to the indication that was found, ABF QC had asked the welder to grind some more until the depth of the grinding was already 10mm. When ABF QC Jesse Cayabyab was asked about the grinding of the linear indication, QC informed this QA that the grinding on the other side of the repair was still in progress and should be covered the same Request for Weld Repair (RWR) that was previously approved. But QA disagreed to

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this interpretation and that the linear indications that were noted on the other side of the just concluded repair should be considered new and an Engineer approval should have been sought prior to the excavation of the linear indications. Due to this infraction, an Incident Report was generated.



Summary of Conversations:

ABF QC Jesse Cayabyab informed this QA that the grinding of the linear indications that were noted at the other side of the just concluded repair at Q face A Y=5770mm was a continuation of the original repair. QA disagreed to this and that an Incident Report was generated due to the infraction committed.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Gary Thomas 916-764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Lizardo, Joselito	Quality Assurance Inspector
Reviewed By:	Reyes, Danny	QA Reviewer
